

Work Order ID 82878

April-10-12 2:35:19 PM

82878

Page 1

Item ID: D4407-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bar

Stop ***NS2***

Start Date: 10/04/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/10 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4407	B

100

0.00

100

Cold Saw

Memo

0.00

cut 12/04/14

30 ~~8~~

Hyd Mech

Cut blanks at 58.12"

110

0.00

110

HAAS 1

Memo

0.00

cut 12/04/15

30 1

HAAS CNC vertical machine #1

1-Mill as per folio FB082 & dwg D4407,

FOLIO REV: 44

DWG REV: B

2-Deburr as required

(PTD)

Dart Aerospace Ltd

W/O: 82878		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4407-3 PAR #: Fault Category: Machining NCR: Yes No DQA: Date: 12/04/23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed ck Date: 12/4/23

NCR: 121359		WORK ORDER NON-CONFORMANCE (NCR) 60.20						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/15	110	1 part pop out of the jig R.L. process	S GS7042 12/04/16	scrap and replace Qty 1 Batch <u>17120696</u>	mf 12/04/15	S 12/04/16	S 12/04/16 GS7042	S 12/04/16

NOTE: Date & initial all entries

Work Order ID 82878***82878***

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Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: *W/A*

0.00

140

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82878***82878***

Page 3

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N900040100Setup Start ***NS1***

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Start Date: 10/04/2012 Start Qty: 30.00

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Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/4/17
P12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-10-12 2:35:23 PM

Page 1

Work Order ID: 82878

82878

Parent Item: D4407-3

D4407-3

Parent Item Name: Bar

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD
12/02/13 new issue JFS verified by:JLM

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	542.9540	4.843	152.9368			

M304B0 250x0 500

**

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

33.874

120696

33.874

MAT050

509.08

121216

509.08

29" *OK 12/04/14*
162

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

C

B

B

A

A

D4407-1 BAR

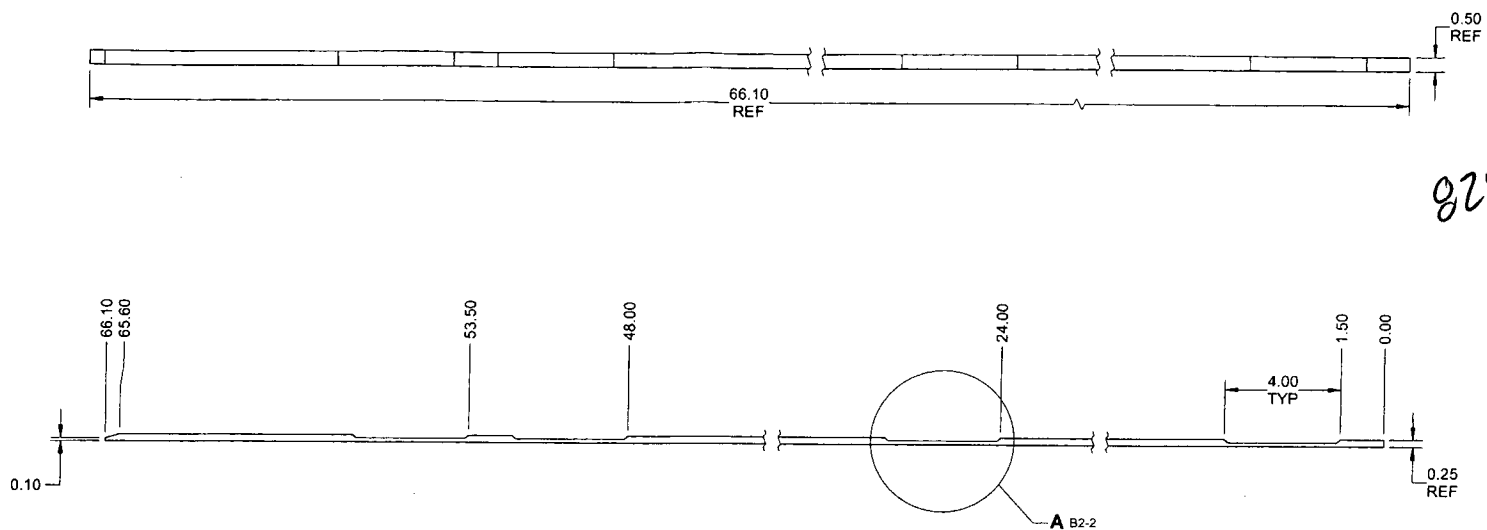
D4407-3 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO 82838-MLJ
12/04/10

RELEASED
2012-02-23
MP

B	REMOVE TOOLING HOLES FOR -1/3; RE-DESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4407	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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D4407-1 BAR

DETAIL A C3-2
TYP. SCALE 2X

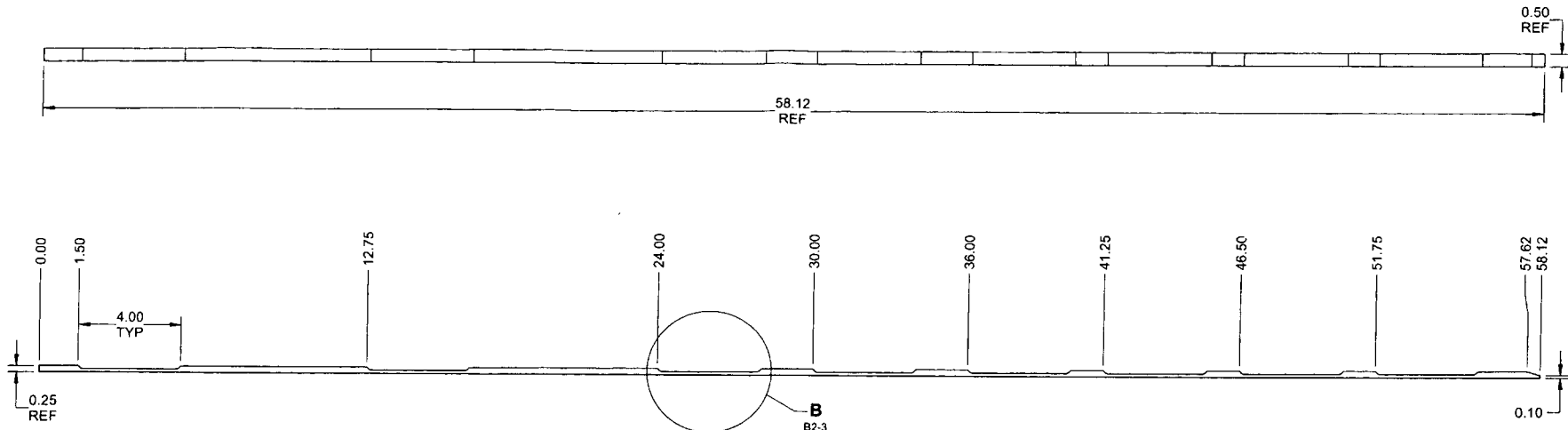
RELEASE
2012-06-10

NOTES:

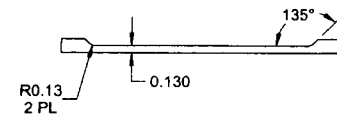
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.11 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4407	SHEET 2 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BAR	NTS
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82870



D4407-3 BAR



DETAIL B C5-3
TYP. SCALE 2X

RELEASED
2012-02-23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: = 1.56 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4407	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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